

Split

Date: Tuesday, 12/18/2007 10:51:27 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARPAD
Job Number	36426			
Estimate Number	12712			
P.O. Number			Part Number	D35371
This Issue	12/18/2007	S.O. No.	Drawing Number	D3537 REV C
Prsht Rev.	NC		Project Number	N/A
First Issue	/ /	Type	Drawing Revision	C
Previous Run	36370		Material	
Written By			Due Date	1/25/2008
Checked & Approved By	<i>12/18/07</i>		Qty:	100
Comment	Est Rev:A New Issue 07-02-14 JLM		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S16GA	304/316 .063 Sheet
	Comment: Qty.: 0.0788 sf(s)/Unit Total: 7.8750 sf(s) M304S16GA .063" 304 SS SHEET Batch: <i>106652 106653 1B 08-1-2</i>	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <i>C</i> Prog Rev: <i>C</i>	<i>1B 08-1-2</i>
		<i>HB 08-1-2</i>
	2-Deburr if necessary	<i>(103)</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<i>1B 08-1-2</i>
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
		<i>OSPO19</i>
	Comment: SECOND CHECK	<i>counted</i>
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE	
	1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1	<i>SD 08/01/08</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36426
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

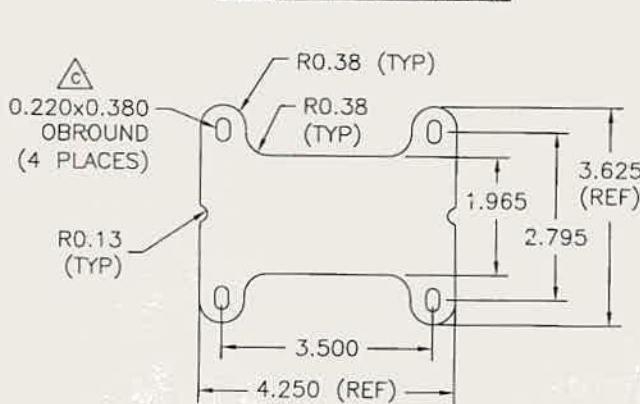
X First Article Prototype

Measured by:	<u>HB</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	08-1-2	Date:	08/01/03	Date:	N/A

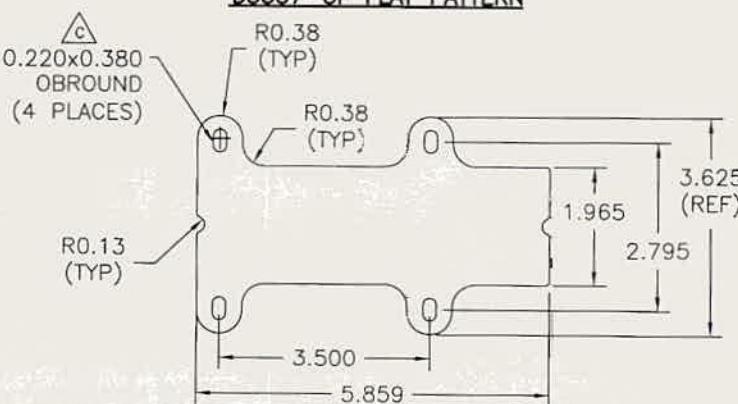
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	✓ ✓



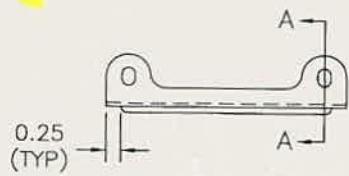
D3537-1F FLAT PATTERN



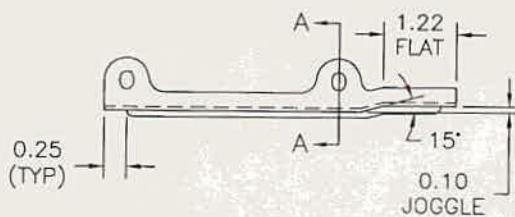
D3537-3F FLAT PATTERN



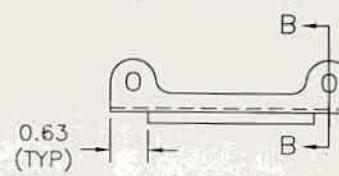
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



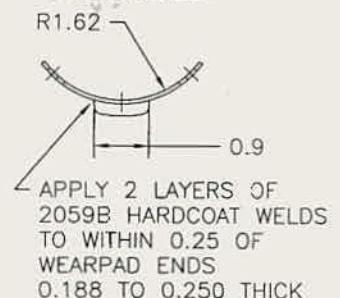
D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

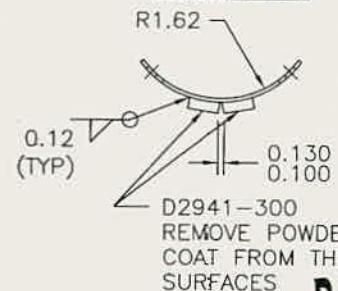
30426

WORK ORDER NO. 30426
SUBJECT TO AMENDMENT
WITHOUT NOTICE
RETURN TO
ENGINEERING
COPIED COPY
DRAFTED COPY

SECTION A-A

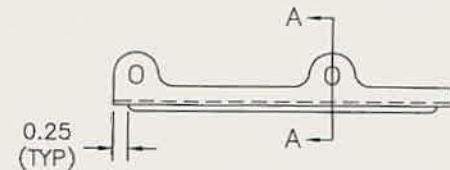


SECTION B-B



RELEASED
07.05.08 AM
PER ELN

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HUENEMER, MA.
C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
CHECKED	APPROVED	DRAWING NO.: D3537 REV. C SHEET 1 OF 1
DATE	TITLE	SCALE WEARPAD 1:2
07.04.13		

